

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM

Page 1

Item ID: D4064-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 10/14/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4064

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg

DWG REV: A

PROG REV: A

6061 .750x 6"

DEBURR IF REQUIRED

AB10-10-26
AB10-11-23 7 (21)

(24)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB10-10-6
AB10-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM



Page 2

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Mill Conv Conventional Milling Machine	Memo MILL RADS, DRILL HOLES AS PER DWG GRIND RAD .060"-.100" BY HAND	0.00 0.00							
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							

~~10/11/08~~
~~10/11/25~~ (19)
PTO →

~~10/11/09~~
~~10/11/25~~ (19)

G.A 10/11/09 20 0
mk 10/11/25 18 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 4064-041 PAR #: Fault Category: ⁽¹⁾ machined parts / ⁽²⁾ small fab w. Jet. NCR: Yes No DQA: Date: 10/11/26
Resolution: ⁽¹⁾ Scrap / ⁽²⁾ Scrap Disposition: ⁽¹⁾ Scrap / ⁽²⁾ Scrap QA: N/C Closed Date: 10/12/01

NCR: <u>62977</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(1) 10/11/25	130	Lug rotated in vise while cutting rad, Qty 2 scrapped. <i>Parts R.C. process</i>	<i> </i> 10/11/25	- Scrap & Destroy. - Parts are being machined on a manual mill.	<i> </i> 10/11/25	<i> </i> 10/11/25	<i> </i> 10/11/25	<i> </i> 10/11/25
(2) 10/11/26	130	Lug Dimension .306 is off on one side actual .285. <i>R.C. process</i>	<i> </i> 10/11/26	Taper due to cutting on the water Jet.	<i> </i> 10/11/26	<i> </i> 10/11/26	<i> </i> 10/11/26	<i> </i> 10/11/26

NOTE: Date & initial all entries

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM



Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2) 10/11/29 (18) 20 10-11-29

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

M115291. START: 11:35
OVENT. 320°
FINISH 12:05.

(2) M115291 START: 1:45 OVENT. 320° FINISH 2:15.
20 10-11-10

180

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

2) 10/11/29 20 10-11-29
2) M115291 18 10-11-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM



Page 4

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Memo ASSEMBLE GROMMETS AS PER DWG	0.00 0.00							
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 Packaging Packaging	Identify as per dwg & Stock Location: <u>462</u> Memo	0.00 0.00							

EP 10/11/30 *EP 10/11/15* *(18x)* *(20)* *FRB*

Sum 130

(18)

10/12/11 *SP* *(18x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4064-041 PAR #: _____ Fault Category: Small Fab. - W-Jet NCR: Yes No DQA: / Date: 10/12/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 10/12/06

NCR: <u>62977</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
③ 10/11/05	190	finish looks is unacceptable rough. parts should have been deburred properly! re-process	W 10-11-05	disassemble - deburr properly to a smooth finish M112567 re powder coat	W 10-11-05 M 11/8	M 11/8	10/11/05	10/12/06
④ 10/11/06	# 190	Found Belur Parts were ground that should have been between Dim .241 + .307 due to the taper of w/J.	10-11-06	BUFFING PARTS RESULTS IN DIMS 0.306 AND 0.241 BELOW ACCEPTABLE TOLERANCE. SCRAP. QTY 20	10-11-06	10/12/06	10/11/06	10/11/06
		R.L. water Jet tape + not caught on inspection work	10/11/06	replace M112567 + 20 pcs.	10-11-30	10/11/30	10/11/06	10/11/06

NOTE: Date & initial all entries

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM

Page 5

Item ID: D4064-041

Accept

Revision ID:

Item Name: Mounting Lug

Start Date: 10/14/2010 Start Qty: 20.00

Required Date: 10/22/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/01 DJ

PS 10-12-1
(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 14, 2010 12:58:38 PM

Page 1

Work Order ID: 62977

Parent Item: D4064-041

Parent Item Name: Mounting Lug

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-03-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X06.00
0

Purchased

No

100

f

38.0800

0.35

7.368421



6061T6 BAR .750 X 6.00



1810-11-23 (21)
1810-10-26

Location

Loc Qty

Loc Code

MAT03

38.08

112567

38.08

MS35489-93

Purchased

No

190

Each

68.0000

2

40



GROMMET



112567 (20)
EP 10/11/15

Location

Loc Qty

Loc Code

ST296

68

115816

6840

1116235 (36)
EP 10/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

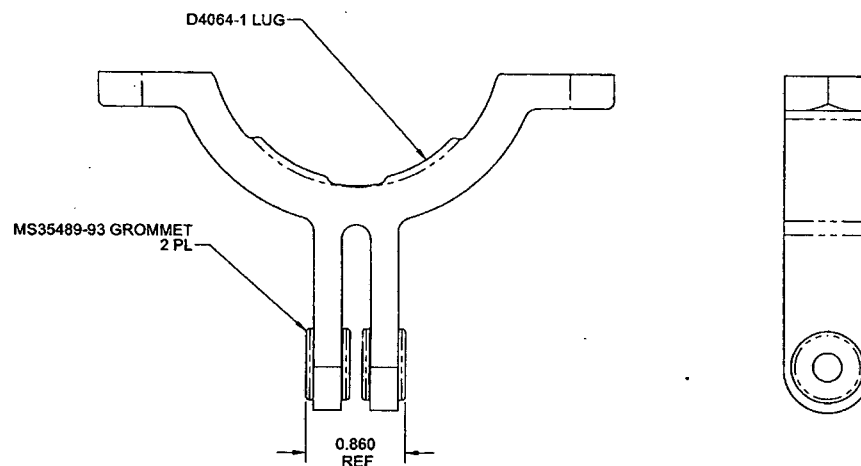
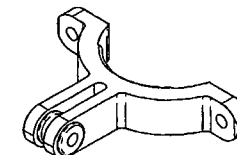
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET



D4064-041 LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

NO. 42977
B/10-10-14

RELEASED
2010-03-01
WD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

A	NEW ISSUE	CP	10.01.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>99</u>		
DRAWN	<u>99</u>		
CHECKED	<u>99</u>		
MFG. APPR.	<u>99</u>		
APPROVED	<u>99</u>		
DE APPR.	<u>99</u>		
DATE	10.01.25		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4064** REV. A
SHEET 1 OF 2

TITLE **CLAMP** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries